

Date: Thursday, 25/10/2007 2:34:50 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: OUTSIDE WASHER		
Job Number	: 35399		Part Number	: D32335		
Estimate Number	: 11154		Drawing Number	: D3233 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 25/10/2007	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 01/11/2007		
Previous Run	: 28620		Qty:	14	Um:	Eac
Written By	:					
Checked & Approved By	:					
Comment	: Est. A 05.03.14 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1020TR1875W250	COLD DRAWN ROUND TUBE
	Comment: Qty.: 0.1860 f(s)/Unit Total : 2.6034 f(s) 1020-1025 Round Tube Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020 SRA or AMS 5075 or AMS 5077 (M1020TR1.875W.250) Identify for D3233-5 Batch: M102210	
2.0	LATHE CONV.	CONVENTIONAL LATHE
	Comment: CONV.LATHE Turn as per Dwg D3233	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE 1- Mill as per dwg D3233 2-Deburr	
5.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	

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Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dan Helicopters Services

Drawing Name: OUTSIDE WASHER

Job Number: 35399

Part Number: D32335

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



CARL



(4)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W523

PGL 07.10.29

7.0 QC21

FINAL INSPECTION/W/O RELEASE

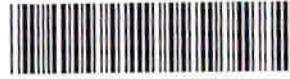


(4)

Comment: FINAL INSPECTION/W/O RELEASE

PGL 07.10.29

Job Completion



U 07.10.29

DART

DESIGN	DRAWN BY
CHECKED	APPROVED
DATE	05.03.08

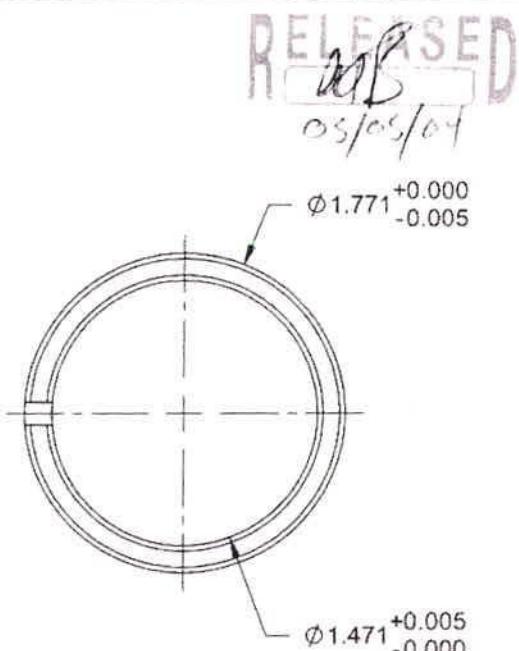
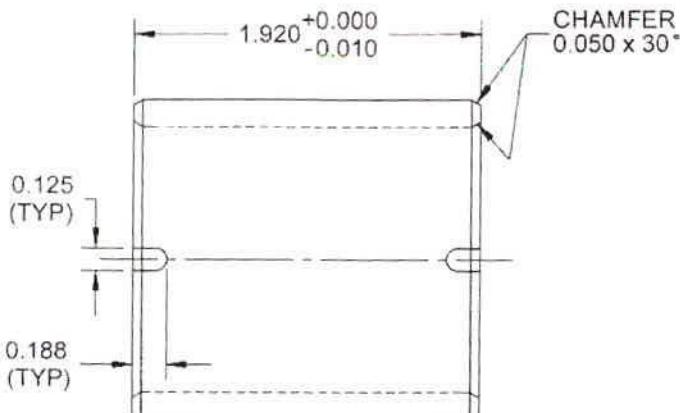
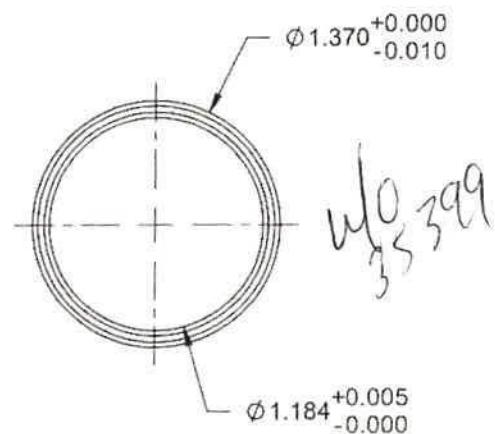
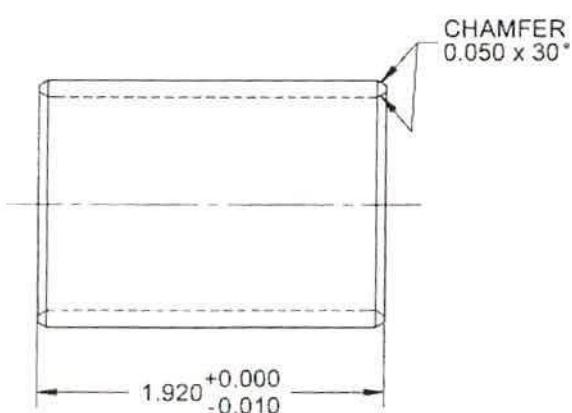
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADADRAWING NO.
D3233

REV. B

SHEET 3 OF 3

SCALE

1:1

**D3233-5 HUB SLEEVE****D3233-7 SHAFT SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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DART AEROSPACE LTD

Work Order: 35399

Description: Hub sleeve

Part Number: D3233-5

Inspection Dwg: D3233 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measuring by:



Date: 07/02/29

Audited by:

二

Date: 07/10/29

Prototype Approval:

47

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	